: SADDLE KIT FOR D206-642-511

: K642 511

: 7/22/2008

: N/A

: N/A

: N/A

User:

Friday, 7/4/2008 8:47:52 AM

Process Sheet

Drawing Name

Part Number

Material

Due Date

Description:

Drawing Number

Project Number

Drawing Revision

: CU-DAR001 Dart Helicopters Services Customer

Job Number : 40258 **Estimate Number** : 12893

P.O. Number

: 7/4/2008 This Issue

: NC

Prsht Rev. : 11 First Issue

: 37360

Previous Run

Written By

Comment

Checked & Approved By

07.06.05 new issue

S.O. No. :

Type

Est Rev.B 08.02.05, Per ECN1080P LL

: SKIDTUBES

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

DOCUMENT CONTROL

1.0 DC



Comment: DOCUMENT CONTROL

CHG003 Photocopy bluefile and create labels per PPP K642-511

PACKAGING RESOURCE #1

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D206648013

GHW Modification



Comment: Qty.:

1.0000 Each(s)/Unit

Total: 2.0000 Each(s)

GHW Kit Batch:

4.0 D2652 Bushing

Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description 3

Bushing

Batch

16 D2652 D2712

Set Screw

Comment: Qty::

10.0000 Each(s)/Unit

20.0000 Each(s) Total:

Pick: Qty Part Number

10 D2712

Description Set Screw







Each

2 Um:

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
<i></i>										
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date:				

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			A				
DATE	STEP	Section A	Initial Chief Eng	Initial Action Description Sign &		Verification Section C	Approval Chief Eng	Approval QC Inspector			
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Friday, 7/4/2008 8:47:52 AM Date: Kim Johnston User: ' **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Part Number: K642 511 Job Number: 40258 Job Number: Description: Seq. #: **Machine Or Operation:** Saddle LH Out, 206 6.0 D29321 Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: **Qty Part Number** Saddle 1 D2932-1 D29331 Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Description, **Qty Part Number** 1 D2933-1 Saddle D2934 Saddle Spacer 4.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: **Qty Part Number** Description 2 D2934 Saddle Spacer Saddle Spacer D2935 4.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: **Qty Part Number** Description 2 D2935 Saddle Spacer Saddle LH Out, 206 D29381 Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: **Qty Part Number** Description D2938-1 Saddle Saddle LH In, 206 D29391 Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Batch **Qty Part Number** Description 1 D2939-1

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _				
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Date: *	Friday, 7/4/2008 8:47:52 AM Kim Johnston	Process Sheet		
. Custo	omer: CU-DAR001 Dart Helicopt	ers Services Drawing Nam	e: SADDLE KIT FOR D206-642-511	
Job Nur	nber: 40258	Part Numbe	er: K642 511	
Job Number				
Seq. #:	Machine Or Operation:	D	escription :	
12.0	D33963	Spacer		
Co	omment: Qty.: 2.0000 Each Pick: Qty Part Number	Description Batch		-A
13.0	2 D3396-3 D3407043	Tow Ring		<u> 5 </u> /
Cr	omment: Qty.: 1.0000 Each Pick:	 (s)/Unit Total : 2.0000 Each(s)	}	
14.0	Qty Part Number 1 D3407-043 T D34561	Description 37373		50
8/1/7				
8	Pick: Qty Part Number 1 D3456-1	(s)/Unit Total: 2.0000 Each(s) Description Batch Washer B4085	8/7/10	SI
15.0	D34571	Washer Rate la sonti		
7	pmment: Qty.: 2.0000 Each(Pick: Qty Part Number 2 D3457-1	(s)/Unit Total: 4.0000 Each(s) Description Batch Washer 37/25		s Q
16.0	AN3C35A	BOLT		,
5 00	omment: Qty.: 3.0000 Each(Pick: QtyPart Number 3 AN3C35A	(s)/Unit Total: 6.0000 Each(s) Description Batch Bolt	,	SP
17.0	AN3C36A	BOLT		(21)
Co	omment: Qty.: 9.0000 Each(Pick: Qty Part Number 9 AN3C36A	(s)/Unit Total: 18.0000 Each(s) Description Bolt / 065 4/	1-14	54
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W/O:		WORK ORDER CHANGES								
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Part No	:	PAR #: Fault Category:	NCR: Yes No DQA:		Date: _					
			QA:	N/C Close	d:	Date:				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Approval Chief Eng	Approval QC Inspector		
DATE	STEP	STEP Section A		Initial Action Description Sign & Chief Eng Chief Eng Date		Verification Section C				
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Date: Friday, 7/4/2008 8:47:52 AM User: " Kim Johnston **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Job Number: 40258 Part Number: K642 511 Job Number: Description: Seq. #: Machine Or Operation: BOLT 18.0 AN3C41A Total: 16.0000 Each(s) Comment: Qty.: 8.0000 Each(s)/Unit Pick: Description ⁻ **Qty Part Number** Batch 8 AN3C41A AN4C6A Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s) Pick: **Qty Part Number** Description Batch Bolt 12 AN4C6A 20.0 AN5C11A Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s) Pick: Description **Qty Part Number** Bolt 8 AN5C11A 21.0 AN5C12A Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: Description **Qty Part Number** Bolt AN5C12A AN5C13A Comment: Qty.: Total: 8.0000 Each(s) 4.0000 Each(s)/Unit Pick: **Qty Part Number** Description Batch 4 AN5C13A Bolt AN5C15A Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: **Qty Part Number** Description , 1 AN5C15A

W/O:		WORK ORDER CHA	NGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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			QA:	N/C Close	d:	_ Date: _	

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Annauci	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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	day, 7/4/2008 8:47:52 AM Process Sheet		
. Customer:	: CU-DAR001 Dart Helicopters Services Drawing Name: SADDLE KIT FOR	D206-642-511	
Job Number:	: 40258 Part Number: K642 511		
Job Number:			
Seq. #:	Machine Or Operation: Description :		
24.0	AN5C32A		
Commo	ent: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick:		
(A)	Qty Part Number Description Batch 2 AN5C32A Bolt		50
25.0	AN5C34A		
Comme	ent: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick:		
Sa	Qty Part Number Description Batch 2 AN5C34A Bolt		50
26.0	AN5C35A		/
Comme	ent: Qty.; 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch		
A.	1 AN5C35A Bolt		50
27.0	AN960C10L washer		
Comme	Pick: Qty: 24.0000 Each(s)/Unit Total: 48.0000 Each(s) Pick: Qty Part Number Description Batch 24 AN960C10L Washer / 0.797/ /082.46		50
28.0	AN960C416L WASHER		(2χ)
Comme	Pick: Qty Part Number Description Batch 24 AN960C416L Washer Washer Washer Washer Washer Description Description		
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W/O:		WORK ORDER CHANGES	-				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Approval Appro				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector			
						:					

Date: Friday, 7/4/2008 8:47:52 AM User: " Kim Johnston **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Job Number: 40258 Part Number: K642 511 Job Number: Description: Seq. #: **Machine Or Operation:** WASHER 29.0 AN960C516L Total: 16.0000 Each(s) Comment: Qty.: 8.0000 Each(s)/Unit Pick: Description Batch **Qty Part Number** 8 AN960C516L Washer MS210433 Comment: Qty.: 20.0000 Each(s)/Unit Total: 40.0000 Each(s) Pick: Description **Qty Part Number** Batch 20 MS21043-3 31.0 MS210434 13.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Description ₂ **Qty Part Number** 13 MS21043-4 MS210435 Nut Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Batch **Qty Part Number** Description 4 MS21043-5Nut D36721 33.0 Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s) PHENOLIC WASHER D36723 Phenolic Washer 34.0 Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s) PHENOLIC WASHER

W/O:		WORK ORDER (CHANGES	
DATE	STEP	PROCEDURE CHANGE	By Date Qty Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category:	NCR: Yes No DQA: Date: _	

QA: N/C Closed: ____ Date: ____

NCR:		,	WORK ORD	ER NON-CONFORMANC	E (NCR)			
		Description of NC	Corrective Action Section B		Varification			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Friday, 7/4/2008 8:47:52 AM User: " Kim Johnston **Process Sheet** Drawing Name: SADDLE KIT FOR D206-642-511 Customer: CU-DAR001 Dart Helicopters Services Job Number: 40258 Part Number: K642 511 Job Number: Description: Seq. #: Machine Or Operation: Phenolic Washer 35.0 D36725 32.0000 Each(s) Comment: Qty.: 16.0000 Each(s)/Unit Total: PHENOLIC WASHER D36727 Phenolic Washer Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s) PHENOLIC WASHER INSPECT 100% KITS FOR COMPLETENESS Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 38.0 Identify and pack for shipping as per PPP K642-511 CHG003 Location: 39.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

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W/O:		WORK ORDI	ER CHANGES			
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			QA: N/	C Closed:	Date:	
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		Description of NC		Corrective Action Section B		Varification	A	Approval QC Inspector			
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